

Date: Tuesday, 19/08/2008 4:04:54 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
 Job Number : 41452  
 Estimate Number : 11295  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : MACHINED PARTS  
 Previous Run : 41201  
 Part Number : D344013  
 Drawing Number : D3440 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 18/09/2008 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : JL 08-8-19  
 Comment : Est. A 05.07.13 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X02000 6061-T6 Bar 2.00 x 2.00



Comment: Qty.: 0.1925 f(s)/Unit Total : 1.9247 f(s)

6061-T6 Bar 2.0" x 2.0"

Material: 6061-T6 or 6061-651/T6510/T6511/T62 Bar (QQ-A-225/8)

(M6061T6B2.000x02.000)

Identify for D3440-13

Batch: M16724

⑪ JL 08/08/28

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank: 2.00" x 2.00" x 2.200" long

⑪ JL 08/08/28

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA539 and Dwg D3440 Dwg Rev: A

Identify as D3440-13

Folio Rev: AA

Deburr

⑪ P.T.O. →

JL DTP 08/08/30

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

⑪ DTP 08/08/30

5.0 QC8 SECOND CHECK



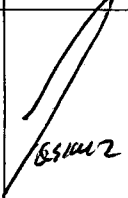



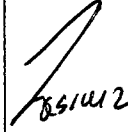



Comment: SECOND CHECK

SA 08/09/02 ⑪

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: D3440-13 PAR #: N/A Fault Category: Prod / Machine NCR: Yes No DQA: D Date: 08/08/05  
 Resolution: PB 67-43001-09 Disposition:  QA: N/C Closed: D Date: 08/08/05

| NCR: <u>41452</u> |      | WORK ORDER NON-CONFORMANCE (NCR)                                    |   |   |                 |   |   |   |
|-------------------|------|---|---|---|-----------------|---|---|---|
| DATE              | STEP | Description of NC<br>Section A                                      | Corrective Action Section B   |   |                 | Verification<br>Section C   | Approval<br>Chief Eng   | Approval<br>QC Inspector  |
|                   |      |   | Initial<br>Chief Eng  | Action Description<br>Chief Eng   | Sign &<br>Date  |   |   |   |
| 08/08/30          | 3.0  | 1 part popped out of vise and the .563" dim was crushed to .540"    |   | I made a block to go in the slot to prevent part from crushing.<br>Scrap and Replace B# 16724 | 08/08/30<br>DTP |   |   |   |
| 08/08/30          | 3.0  | 1 part the .450" dim. is .400 caused by bad origine operator error. |  | Took new origine<br>Scrap and Replace B# 16724  | 08/08/30<br>DTP |  |  |  |
|                   |      |   |   |   |                 |   |   |   |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:54 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41452

Part Number: D344013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 134

DS 08/09/03 (AC)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/03 /g

Job Completion



MF 08-09-03

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

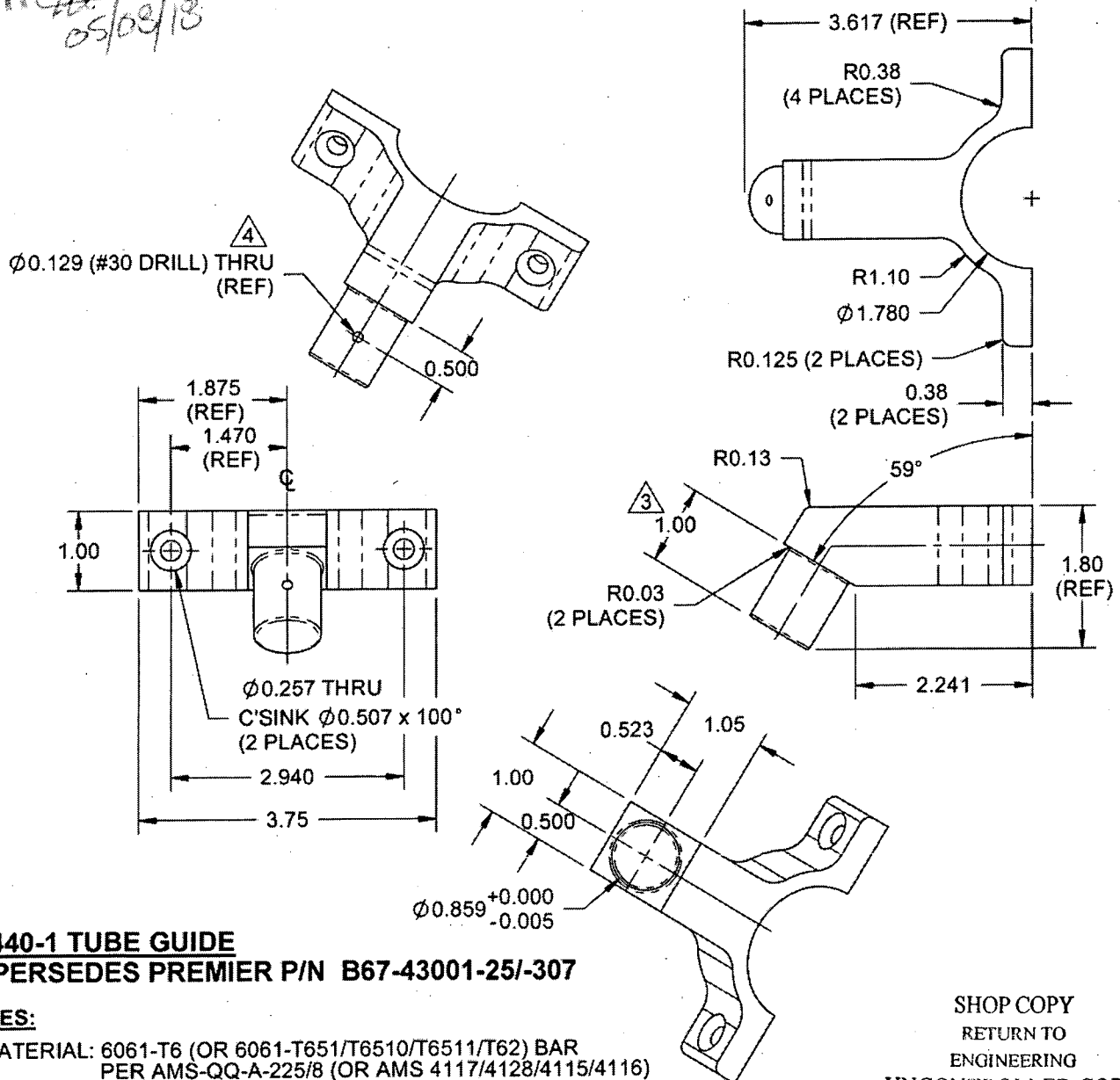
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

|                         |                         |  |                        |
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| DATE<br><b>05.06.02</b> |                         | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:2           |
| A                       | 05.06.02                | NEW ISSUE  |                        |

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**D3440-1 TUBE GUIDE**  
**SUPERSEDES PREMIER P/N B67-43001-25/-307**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT-A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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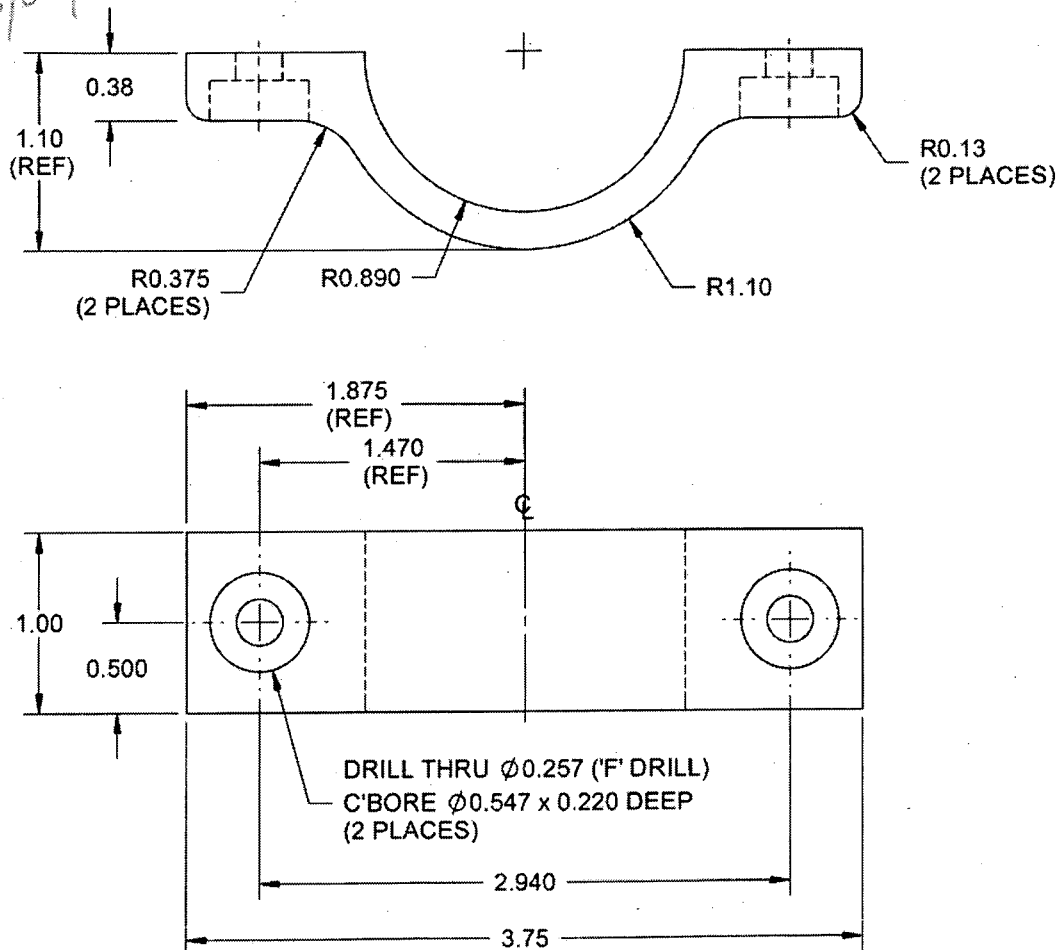
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| DATE<br><b>05.06.02</b>       |                                | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |

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05/08/18

**D3440-3 CLAMP****SUPERSEDES PREMIER P/N B67-43001-309****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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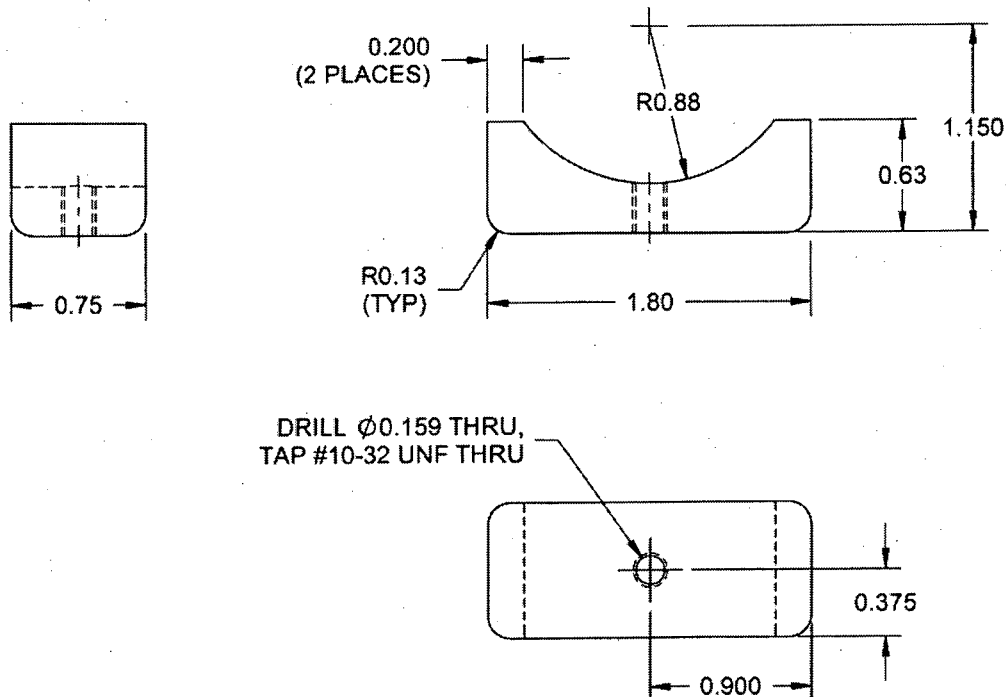
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| DATE<br><b>05.06.02</b> |                         | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |

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**D3440-5 CONTOURED DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-217**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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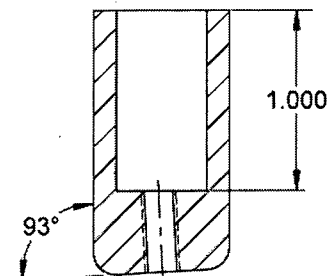
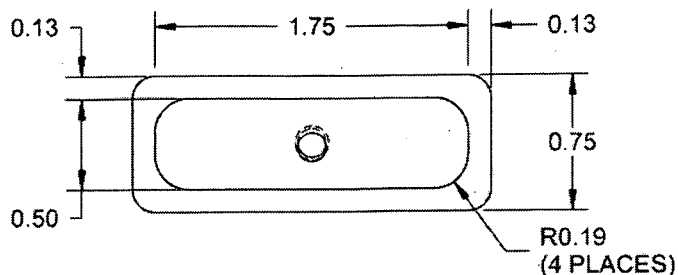
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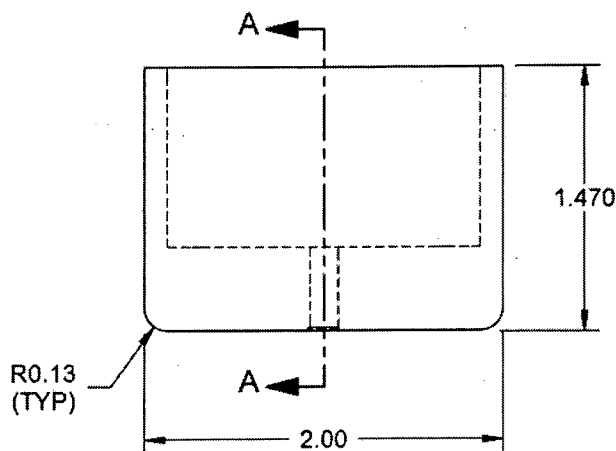
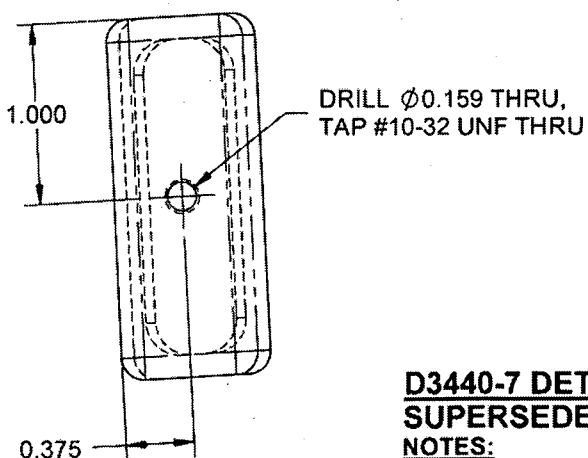
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| DATE<br><b>05.06.02</b>       |                                | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |

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SECTION A-A



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**D3440-7 DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-221**

NO. 41452

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

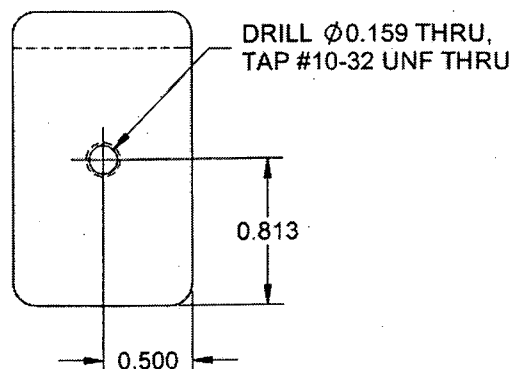
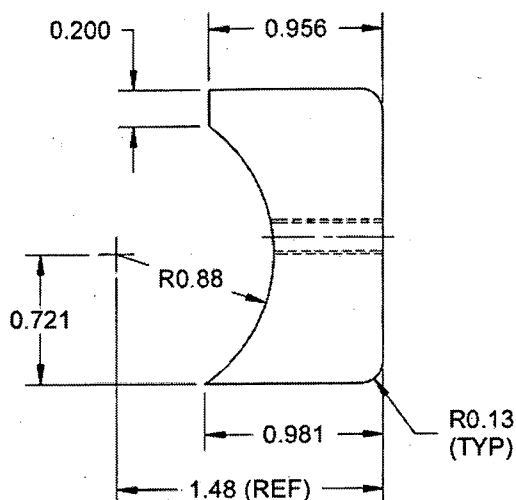
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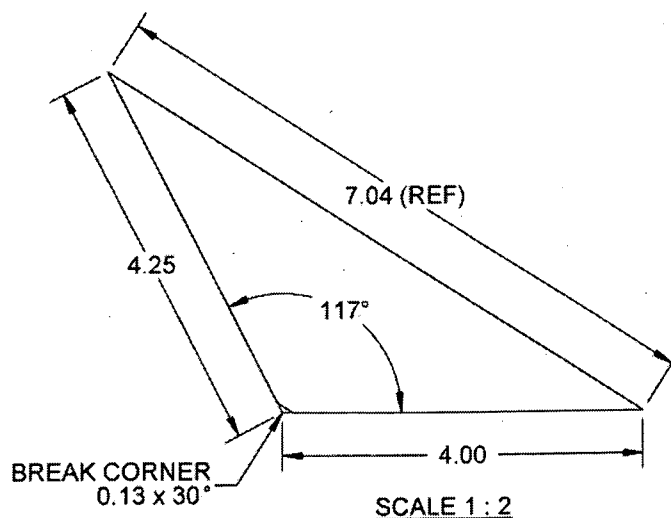
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| DATE<br><b>05.06.02</b>       |                                | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

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05/08/13



**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

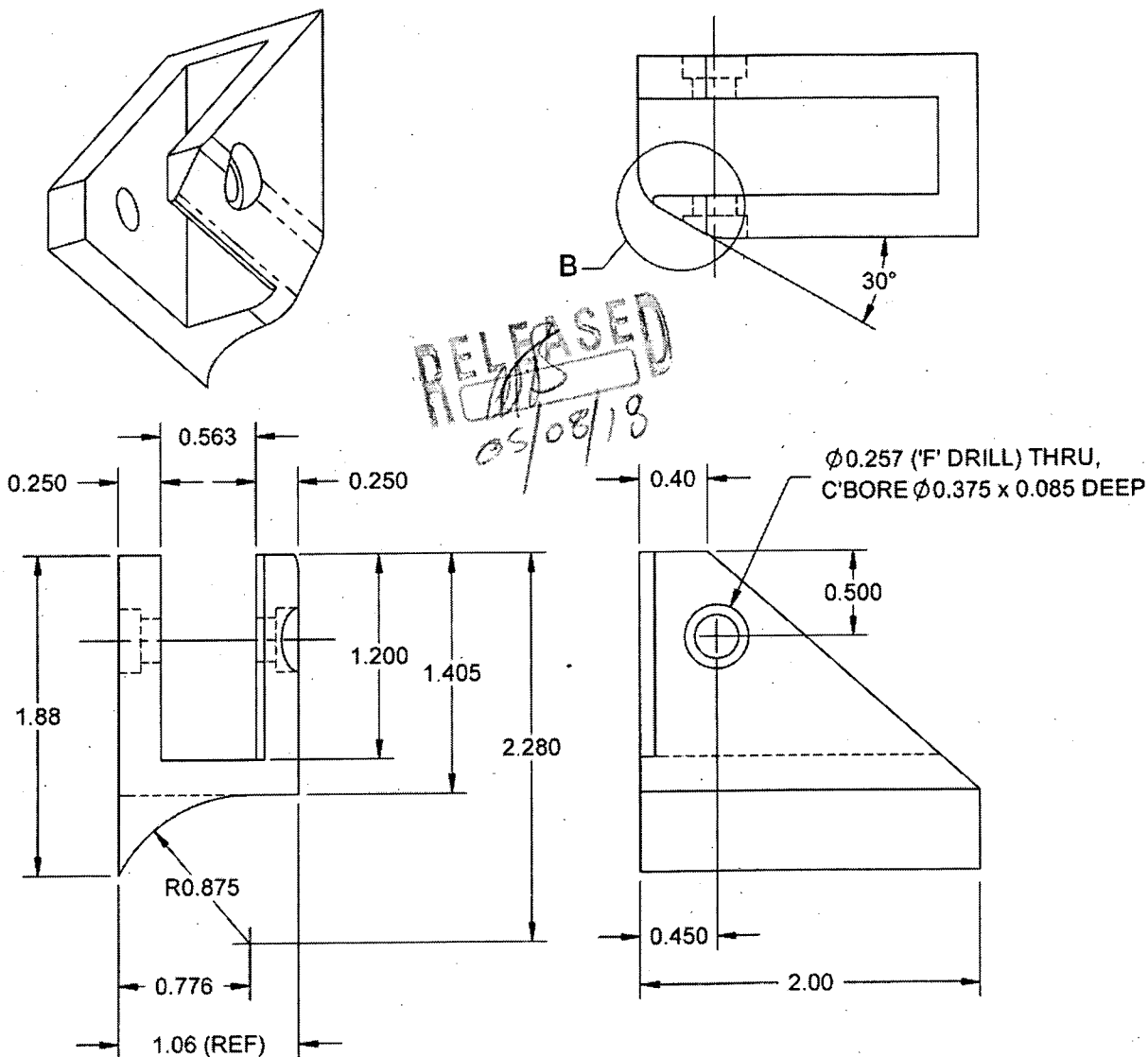
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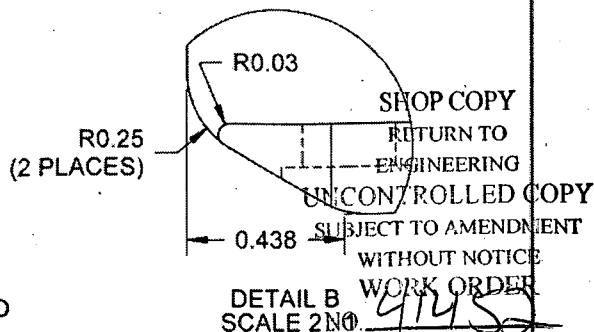
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| DATE<br><b>05.06.02</b>       |                                | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |



**D3440-13 BRACKET**  
**SUPERSEDES PREMIER P/N B67-43001-273**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



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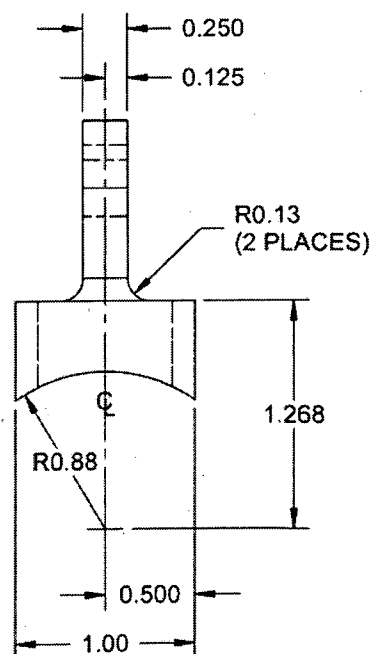
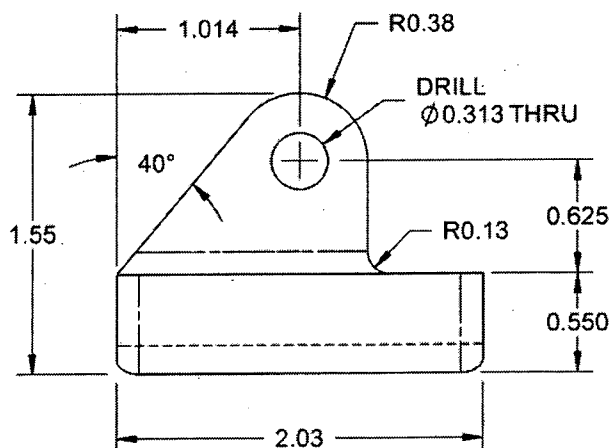
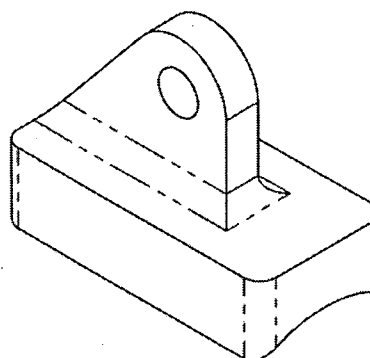
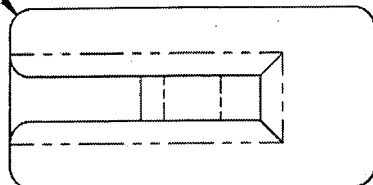
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| DATE<br><b>05.06.02</b>      |                                | TITLE<br><b>BLADE FOLD KIT PARTS</b>                     | SCALE<br>1:1           |

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05/08/18

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE**  
**SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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|                      |      |                      |
|----------------------|------|----------------------|
| DART AEROSPACE LTD   |      | Work Order: 41452    |
| Description: Bracket |      | Part Number: 3440-13 |
| Inspection Dwg:      | Rev: | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 30°               | ± 1/2°        | 30°              | ✓      |        |                      |          |
| 0.40              | ± 0.030       | 0.400            | ✓      |        |                      |          |
| 0.500             | ± 0.010       | 0.505            | ✓      |        |                      |          |
| 0.450             | ± 0.010       | 0.447            | ✓      |        |                      |          |
| 2.00              | ± 0.030       | 2.006            | ✓      |        |                      |          |
| 0.776             | ± 0.010       | 0.776            | ✓      |        |                      |          |
| 1.06              | ± 0.030       | 1.063            | ✓      |        |                      | (REF)    |
| R0.875            | ± 0.010       | 0.875            | ✓      |        |                      |          |
| 2.280             | ± 0.010       | 2.280            | ✓      |        |                      |          |
| 1.460             | ± 0.010       | 1.401            | ✓      |        |                      |          |
| 1.200             | ± 0.010       | 1.199            | ✓      |        |                      |          |
| 1.88              | ± 0.030       | 1.866            | ✓      |        |                      |          |
| 0.563             | ± 0.010       | 0.565            | ✓      |        |                      |          |
| 0.250             | ± 0.250       | 0.248            | ✓      |        |                      |          |
| 0.250             | ± 0.010       | 0.248            | ✓      |        |                      |          |
| φ 0.257           | +0.006/-0.001 | 0.259            | ✓      |        |                      |          |
| φ 0.375           | +0.006/-0.001 | 0.376            | ✓      |        |                      |          |
| 0.085(deep)       | ± 0.010       | 0.086            | ✓      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                  |
|------------------|
| Measured by: DIP |
| Date: 08/08/30   |

|                         |
|-------------------------|
| Audited by: [Signature] |
| Date: 08/07/0           |

|                         |
|-------------------------|
| Prototype Approval: N/A |
| Date: N/A               |

| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |